

Work Order ID 111826

January-23-14 9:48:08 AM

Split - 1

111826

Page 1

Item ID: D3137-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Guide

Start Date: 1/23/14

Start Qty: 30.00

Required Date: 2/06/14

Req'd Qty: 30.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MJS

Date: 14-01-23 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3137

Rev F

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut Blanks.Blank size: 1.250" x .750" x .950" long

50 ϕ

DR 14-01-30

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per Folio FA242 & Dwg D31372-Deburr

35 ϕ

DR 14-01-31

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

35 ϕ

DR 14-01-31

Work Order ID 111826

January-23-14 9:48:08 AM

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Page 2

Item ID: D3137-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Guide

Start Date: 1/23/14 Start Qty: 30.00

30

Cust Item ID:

Required Date: 2/06/14 Req'd Qty: 30.00

30

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

only 14/02/02

35 x

140

Identify as per dwg & Stock Location: 27235A

0.00

140

Packaging

Memo

0.00

Packaging

35x ^{DAS} 28 14-02-3
9-89

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

MCS 14-02-03

14-02-03

Picklist Print

January-23-14 9:48:14 AM

Page 1

Work Order ID: 111826

111826

Parent Item: D3137-3

D3137-3

Parent Item Name: Guide

Start Date: 1/23/14

Required Date: 2/06/14

Start Qty: 30.00

Required Qty: 30.00

Comments:

IPP Rev:A02.05.29New IssueNG

IPP Rev:B 08-05-23 revE as per dwg DD verified by:EC

IPP Rev:c 08.07.03 ECN1207 EC verified by DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MDEL RINB0.75X1.250

Purchased

No.

100

f

9.8440

0.0791

3

MDEI RINB0 75X1 250

**

Delrin Bar

DP
14-01-30

Location

Loc Qty

Loc Code

MAT039

9.844

m127442

9.844

5 ft.

DART AEROSPACE LTD

Work Order:	111826
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Description: Guide

Part Number:	D3137-3
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Inspection Dwg: D3137 Rev: F

Page 1 of 1

[illegible]

Measured by:

Audited by:

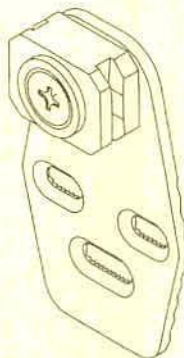
Preliminary Approval:

Date: 14-01-31

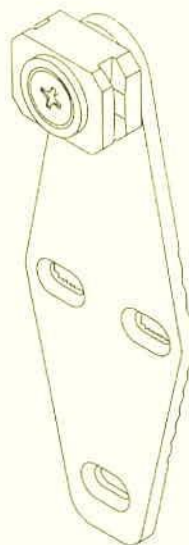
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Date:

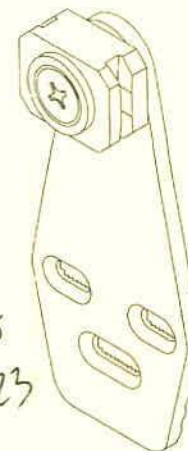
Rev	Date	Change	Revised by	Approved
A	03.11.27	New Issue	KJ/RF	
B	04.11.12	0.175 was 0.145 & Ø0.65 x 100° was Ø0.75 x 100°	KJ/JLM	
C	06.03.15	Dwg Rev updated	KJ/JLM	
D	08.12.02	Dwg Rev updated	KJ/DD	
E	13.09.10	Dimension revised per Dwg Rev F	KJ	



D3137-041 BRACKET ASSEMBLY



D3137-043 BRACKET ASSEMBLY



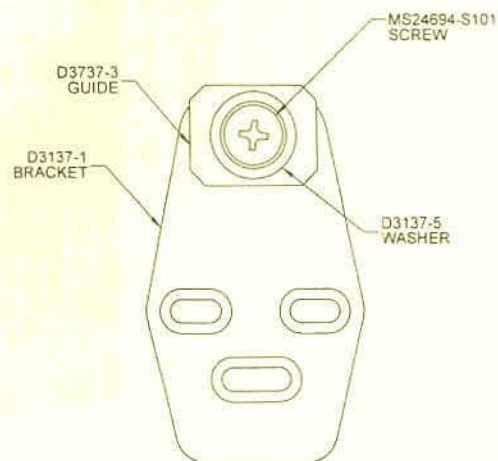
D3137-045 BRACKET ASSEMBLY

111826 MLJ
14-01-23

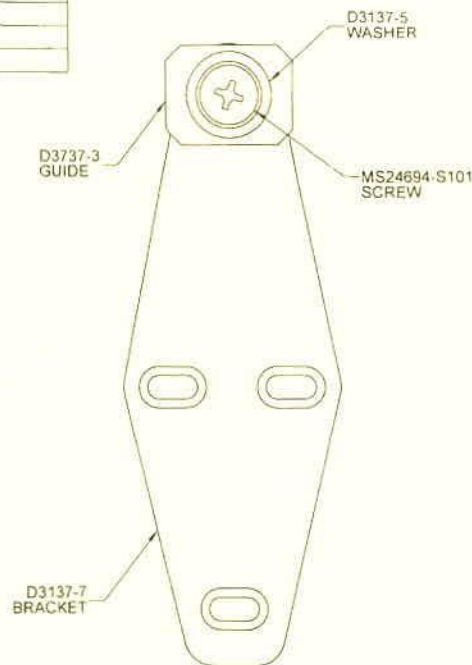
RELEASE
06-21-04

F	REDRAWN & REFORMATTED IN SOLIDWORKS. SHEET 3 ZONE A 5 DIM 2.36 WAS 2.48, ZONE A 4 0.480 DIM WAS 0.605, ZONE A 8 0.67 DIM WAS 0.79, ZONE B 5 4.650 DIM WAS 4.975 & ZONE B 8 5.28 DIM WAS 5.41. REASON: PART TRIMMED DUE TO INTERFERENCE WITH EXECUTIVE INTERIOR.	AJS	08 05 30
E	ADD -045	RF	05 11 23
D	RE-DESIGN D2137-5. CHANGE DIMS	DS	04 11 03
C	ADD -043	DS	03 06 15
B	ADD RIDGES, ADD MATERIAL PROP	DS	03 01 16
A	NEW ISSUE	DS	02 04 17
REV	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO	REV F
MFG APPR		D3137	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR		BRACKET ASSEMBLY	NTS
DATE	08 05 30	COPYRIGHT © 2002 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

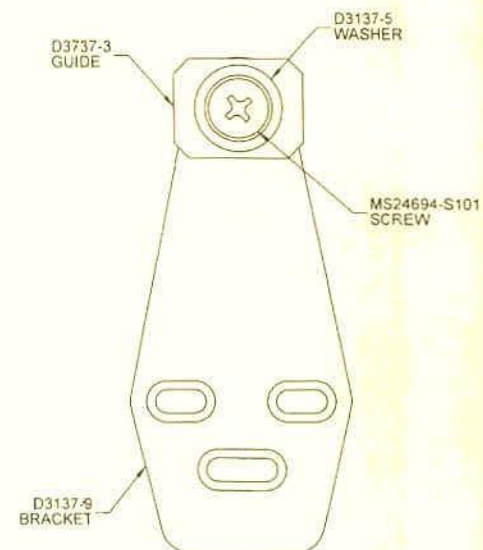
QTY. -041	QTY. -043	QTY. -045	PART NUMBER	DESCRIPTION
X			D3137-041	BRACKET ASSEMBLY
	X		D3137-043	BRACKET ASSEMBLY
		X	D3137-045	BRACKET ASSEMBLY
1			D3137-1	BRACKET
1	1	1	D3137-3	GUIDE
1	1	1	D3137-5	WASHER
	1		D3137-7	BRACKET
		1	D3137-9	BRACKET
1	1	1	MS24694-S101	SCREW



D3137-041 BRACKET ASSEMBLY



D3137-043 BRACKET ASSEMBLY



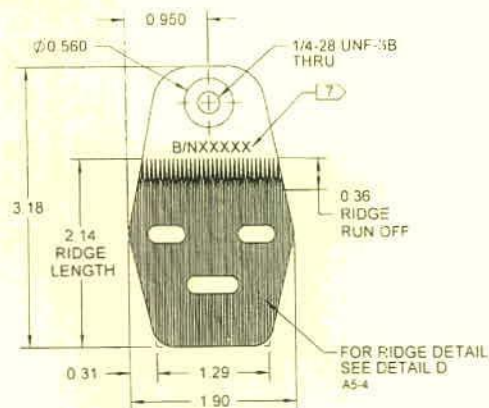
D3137-045 BRACKET ASSEMBLY

NOTES

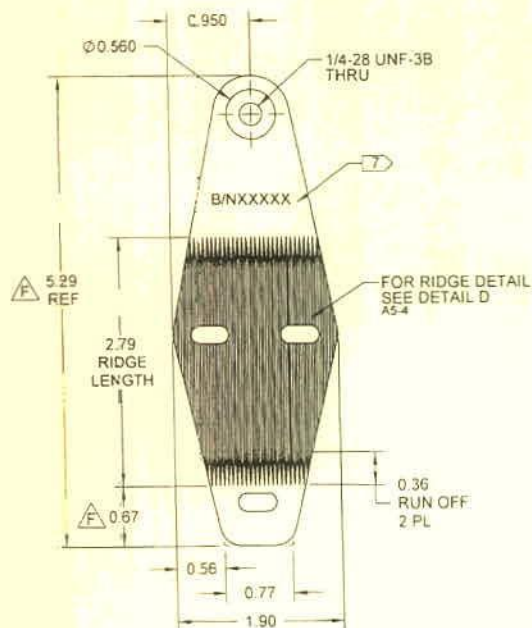
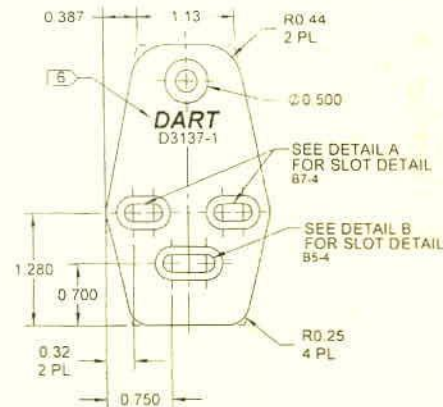
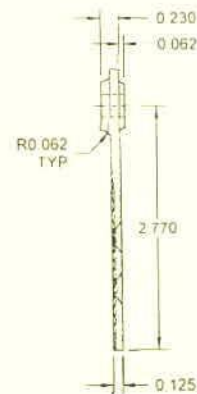
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.18 lbs -041
0.32 lbs -043
0.27 lbs -045

RELEASED
08-06-16/11

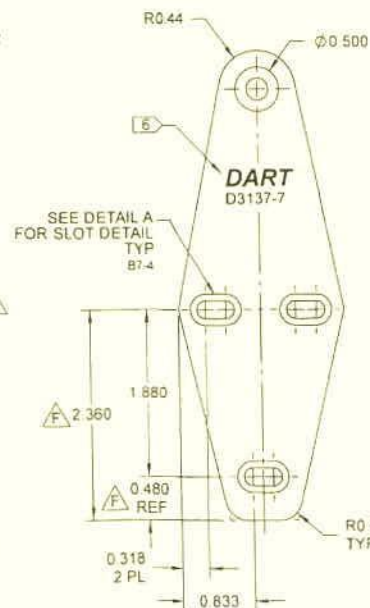
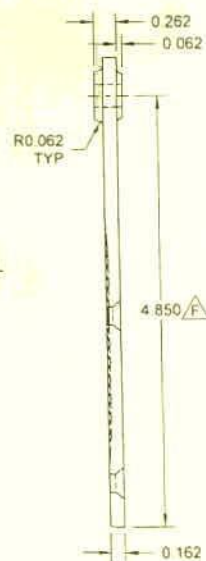
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DRAWN	A/S	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV F
MFG. APPR.		D3137	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BRACKET ASSEMBLY	NTS
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D3137-1 BRACKET



D3137-7 BRACKET

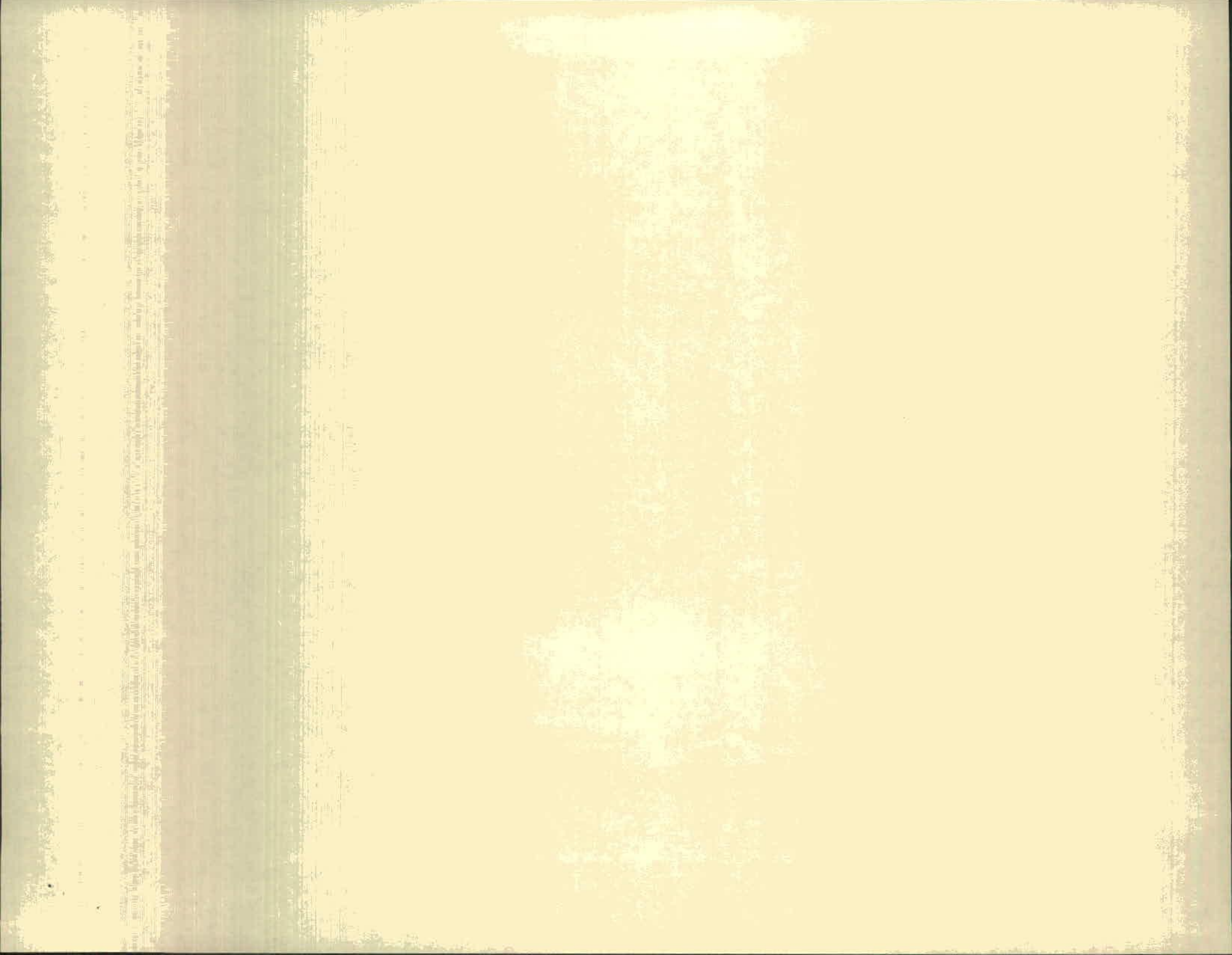


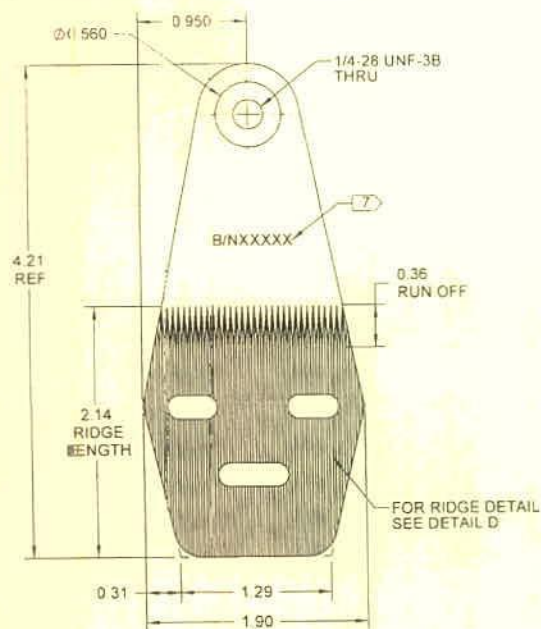
NOTES

- 1) MATERIAL: -1 & -7
17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
PER DART SPEC. M17-4-B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: ENGRAVE DART LOGO USING 0.20 HIGH LETTERS & P/N WITH USING 15 HIGH LETTERS TO A MAX. DEPTH OF 0.010
- 7) SCRIBE WITH DART B/N USING VIBRATING STYLUS
- 8) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 9) -1 REPLACES PREMIER P/N B30-23000-1054-05

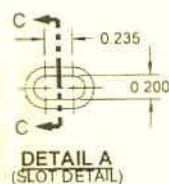
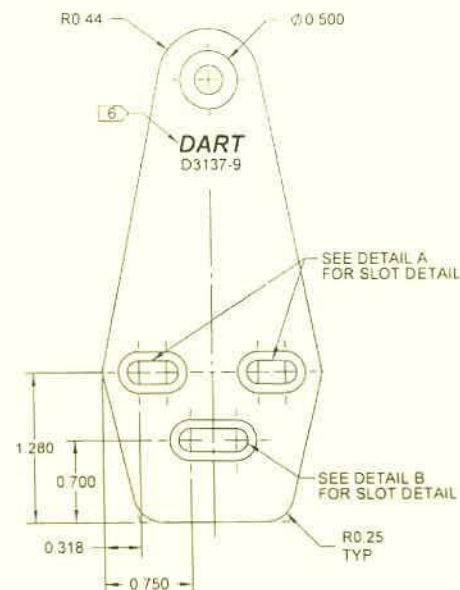
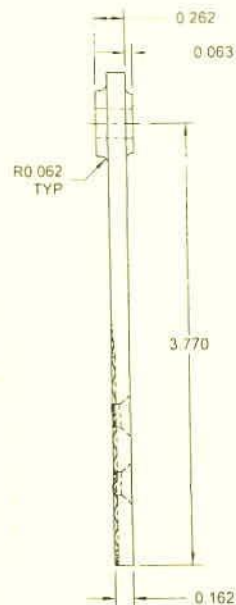
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CHECKED		DRAWING NO	REV. F
MFG APPR		D3137	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR		BRACKET ASSEMBLY	NTS
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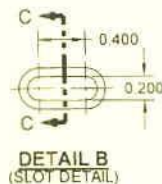




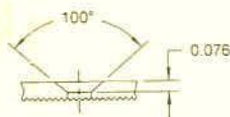
D3137-9 BRACKET



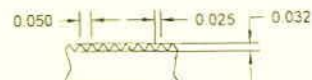
**DETAIL A
(SLOT DETAIL)**



**DETAIL B
(SLOT DETAIL)**



**SECTION C-C
(SLOT DETAIL)**



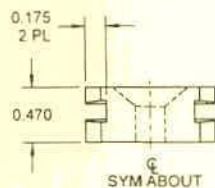
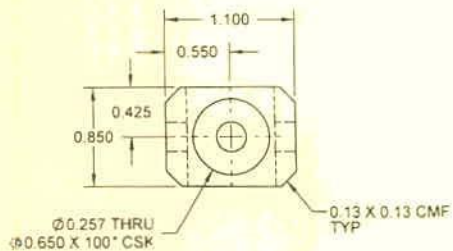
**DETAIL D
SCALE 2X
(TYPICAL RIDGE DETAIL)**

RELEASED

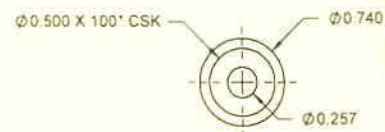
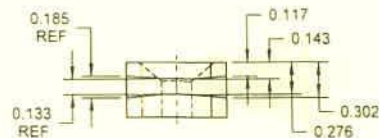
NOTES

- 1) MATERIAL 17-4PH STAINLESS STEEL
PER AMS 5604 OR 5643
MIN ULTIMATE TENSILE = 150 KSI
MIN YIELD TENSILE = 100 KSI
PER DART SPEC. M17-4-B
- 2) FINISH NONE
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION ENGRAVE DART LOGO USING 0.20 HIGH LETTERS & P/N WITH USING 15 HIGH LETTERS TO A MAX. DEPTH OF 0.010
- 7) SCRIBE WITH DART B/N USING VIBRATING STYLUS
- 8) WEIGHT SEE ASSEMBLED WEIGHT ON SHEET 2
- 9) REPLACES PREMIER P/N B30-23000-105/1-106

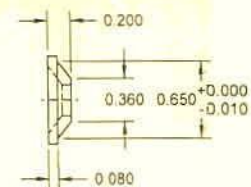
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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO	REV. F
MFG APPR		D3137	SHEET 4 OF 5
APPROVED		TITLE	SCALE
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D3137-3 GUIDE



D3137-5 WASHER



NOTES:

- 1) MATERIAL: -3
DELIN II 150E OR ACETRON GP ACETAL BAR
(REF DART SPEC M-DELIN-B)
-5
6061-T6 (OR 6061-T651/ T6510/ T6511/ T62) ALUMINUM BAR
PER-AMS-QQ-A-225/8 (OR AMS 4117/ 4128/ 4145/ 4115)
OR PER-QQ-A-200/8 (OR AMS 4160)
REF. DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 (-5 ONLY)
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE ASSEMBLED WEIGHT ON SHEET 2
- 8) -3 REPLACES PREMIER P/N B30-2300-207
-5 REPLACES PREMIER P/N B30-2300-209

RELEASED

DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	LAJS		
CHECKED	J	DRAWING NO	REV. F
MFG APPR.	41	D3137	SHEET 5 OF 5
APPROVED	140	TITLE	SCALE
DE APPR	14	BRACKET ASSEMBLY	NTS
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